

BLUE

Wednesday, 5/16/2007 8:13:38 AM  
Kim Johnston

## Process Sheet

SPLIT-1

23

Customer No	CU-DAR001	Dart Helicopters Services	Drawing Name	206/0H-68 SADDLE, INBOARD, LEFT SIDE
Estimate Number	32379			
O Number	N/A		Part Number	D29331
Date Issue	5/16/2007	S.O. No. N/A	Drawing Number	D2933 REV C
First Rev.	NC		Project Number	N/A
2nd Issue	N/A	Type MACHINED PARTS	Drawing Revision	C
Previous Run	32022		Material	N/A
Entered By			Due Date	5/6/2007
Checked & Approved By			Qty:	16 Unit
Comment		Est: B 00.06.26 New DWG rev (mpp 2069) EC		
		Est Rev.C As per Rev.C 07-03-19 JLM		

Journal Product

Part Number	
-------------	--

Seq. #	Machine Or Operation:	Description:
1.0	D5101001	7075-T7351 2X6X6.25

Comment: Qty: 1.0000 Each(s)/Unit Total: 16.0000 Each(s)

Issue material from stock: 7075-T7351 QQ-A-250/12

Cut Size 2.0 x 6.25 X 6.00

Grain Along Long 6.00 Length

Batch No. B31356

2.0	HAAS	HAAS CNC VERTICAL MACHINING #1
-----	------	--------------------------------

Comment: HAAS CNC VERTICAL MACHINING #1

Program part number and batch number.

1-Inspect part number and batch number are programmed correctly.

2-Machine Step No 1 of Folio and visually inspect as per dwg D2933 &amp; attached Dimension Sheet

3-Machine Step No 2 of Folio and visually inspect as per dwg D2933 &amp; attached Dimension Sheet

4-Machine Step No 3 of Folio and visually inspect as per dwg D2933 &amp; attached Dimension Sheet

5-Deburr

3.0	MILLING CONV	CONVENTIONAL MILLING MACHINE
-----	--------------	------------------------------

Comment: CONVENTIONAL MILLING MACHINE

Machine Keyway and inspect per attached dimension sheet

4.0	Q01	INSPECT ALL DIM TO DIM SHEET
-----	-----	------------------------------

Comment: INSPECT ALL DIM TO DIM SHEET

Date: Wednesday, 07/10/2007 0:13:30 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/OH-58 SADDLE, INBOARD, LEFT SIDE

Job Number: 32379

Part Number: D29331

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC8

SECOND CHECK



Comment: SECOND CHECK

J-F-07/06/07 (7)

6.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1



(2x)

7.0 SPRAY PAINTING

SPRAY PAINTING



7/10:4058 (2) 07/06/07 (2)



Comment: SPRAY PAINTING

-PRIME

-PAINT DELFLEET BLUE

-CLEAR DELFLEET

8.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock  
Location: \_\_\_\_\_

P-7/2/07 (2)

9.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

R 07/07/07 (2)

at Completion



U 07.07.07

→ 7.1) QC 14

202-07-03 2

DART AEROSPACE LTD	Work Order:	32379
Description: 206 Saddle, Inboard, Left side	Part Number:	D2933-1
Inspection Dwg: D2933 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2933 Rev. C and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		0.126	1.27	1.26	1.27		
B	0.100	0.140		0.127	1.26	1.24	1.27		
C	0.100	0.140		0.120	1.26	1.30	1.25		
D	0.210	0.230		0.224	2.25	2.24	2.24		
E	1.245	1.255		1.249	1.250	1.250	1.250		
F	1.245	1.255		1.249	1.250	1.250	1.250		
G	2.495	2.505		2.499	2.500	2.500	2.500		
H	0.510	0.515		0.510	-510	-510	-510		
I	1.572	1.582		1.576	1.577	1.577	1.577		
J	2.495	2.505		2.494	2.501	2.501	2.500		
K	0.257	0.262		0.258	2.58	2.58	2.58		
L	0.312	0.317		0.314	-314	-314	-314		
M	0.235	0.240		0.240	2.40	2.40	2.40		
N	0.100	0.140		0.126	1.26	1.26	1.25		
O	0.540	0.560		0.550	-551	-555	-555		
P	0.490	0.510		0.502	1.56	1.58	1.56		
Q	3.715	3.725		3.717	3.717	3.715	3.715		
R	2.470	2.510		2.494	2.494	2.494	2.494		
S	0.240	0.270		0.252	-259	-254	-254		
T	0.100	0.180		0.132	1.37	1.37	1.37		
U	1.625	1.635		1.631	1.630	1.630	1.630		
V	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321		0.320	-320	-320	-320		
X	1.125	1.145		1.136	1.136	1.136	1.136		
Y	1.565	1.585	DT8695 A/B	1.574	1.575	1.575	1.575		
Z	0.178	0.198		0.188	-188	-188	-188		
AA									
AB									
AC									
AD									
AE									
AF									

Accept/Reject

Measured by:	Mel / SA	Audited by:	J.F.
Date:	07.06.26	Date:	07/06/27

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	06.10.03	Removed DT8683, DT8686 & DT8690	KJ/JLM	
D	07.03.21	Revised per drawing revision C	KJ/JLM	